303 . 500

Work Order ID 101452

Monday, May 13, 2013 11:18:46 AM

101452

Item ID: D3439-3 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Stud **Stop** *NS2*

Start Date: 5/13/2013 **Start Qty:** 24.00 *24*

Required Date: 5/17/2013 **Req'd Qty:** 24.00 *24*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MM **Date:** 18-5-13 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Draw Nbr	Revision Nbr
D3439	B

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100		0.00							
100						24	∅		
Hardinge	**Memo**	0.00							
Hardinge CNC Lathe Small	TURN AS PER FOLIO FA959 FOLIO REV: AA DWG REV: B	SJ/FK 13/05/16							
	DEBURR								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110						24	∅		
QC	**Memo**	0.00							
Quality Control		SJ/FK 13/05/16							

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Work Order ID 101452

Monday, May 13, 2013 11:18:46 AM

101452

Item ID: D3439-3 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Stud

Start Date: 5/13/2013 **Start Qty:** 24.00 *24*
Required Date: 5/17/2013 **Req'd Qty:** 24.00 *24*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120			ok 13/05/17			24	0		
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: C-A	0.00							
130						24			13/05/17
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									13/5/17
QC	Memo	0.00							
Quality Control									

MCJ 13-05-17

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

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- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

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Doc/Data	☐									
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- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Picklist Print

Monday, May 13, 2013 11:18:46 AM

Work Order ID: 101452
Parent Item: D3439-3
Parent Item Name: Stud

Start Date: 5/13/2013 **Required Date:** 5/17/2013
Start Qty: 24.00 **Required Qty:** 24.00

Comments: IPP Rev:A 10.09.08 new issue verf:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.500 303 Round Bar 0.500"		Purchased	No			100	f	76.5333	**0.113**	**2.8547368**			

Location	Loc Qty	Loc Code
MAT028	76.53330000	
124081	1E-09	
124711	28.2	
125387	48.3333	

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NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

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- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

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Training	☐									
Unapproved	☐									

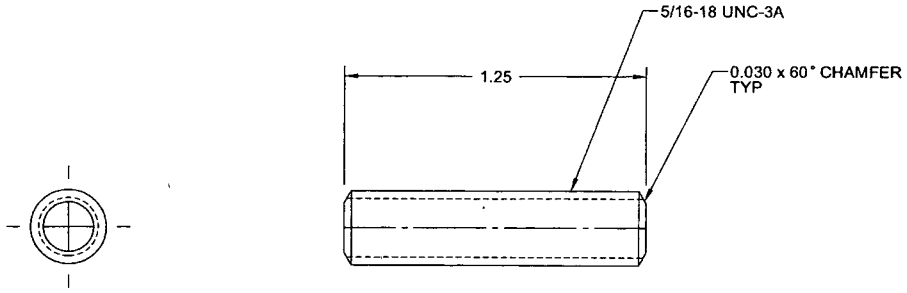
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D3439-3 STUD (B)

101452

RELEASED
2010 -09- 07

NOTES:
1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010
6) IDENTIFICATION: NONE
7) WEIGHT: 0.03 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3439 REV. B
MFG. APPR.		SHEET 2 OF 2
APPROVED		TITLE MIRROR ASSEMBLY SCALE NTS
DE APPR.		
DATE 10.07.20		

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DART AEROSPACE LTD	Work Order:	10452
Description: Stud	Part Number:	D3439-3
Inspection Dwg: D3439 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/-0.030	1.248	✓		DI-9	Vern
5/16-18 UNC-3A	N/A		✓			
Major Ø	Max = 0.3125 Min = 0.3038	.308	✓		DI-5	Mic
M.O.W.	Max = 0.3245 Min = 0.3215	.323	✓		"	"

Measured by:	SJV/FK	Audited by:		Preliminary Approval:	
Date:	3-5-15	Date:	3/10/16	Date:	

Rev	Date	Change	Revised by	Approved
A	11.06.21	New Issue	KJ	

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